

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004811**Date Inspected:** 25-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Lvliqing and Huang Wen Pang			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG and SAS Tower Fabrication		

Summary of Items Observed:

On this date, Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector Joselito Lizardo was present as requested to perform observations on the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China.

The QA Inspector has randomly observed the following activities on sub-assembly Bays mentioned below;

Bay 7: OBG - Floor Beam Sub Assembly

This QA observed ZPMC/NDE perform MT on OBG floor beams FB009-015-004, 010, 013, FB015-020-002, 010, 013, 014. This QA also perform 10% MT on just mentioned beams but Floor beam FB016-017-004, 010, 013 was not done due to pending UT repair on CJP joint. Also observed ZPMC/NDE Tany Xing and Xu Rung Gong perform UT on various corner assemblies.

This QA also observed ID #044774 and ID #044830 FCAW(1G) CJP welding root pass on flange to web plate tee joint FB024-004-127 and FB023-003-127 respectively using a 1.4mm diameter electrode, filler metal brand E71T-1, class Supercored 71H, semi automatic and following WPS-B-T-2231-Tc-U4b-F. The QA Inspector randomly observed ZPMC CWI Huang Wen Pang monitoring preheat and weld parameters.

FCAW(2F) fillet welding on stiffener and flange to web plate of floor beam FB027-003-022/023 utilizing the FCAW Process with a 1.4mm diameter electrode, filler metal brand E71T-1, class Supercored 71H following WPS-B-T-2132-3 this QA observed. ZPMC welder ID #044815 was seen performing the task. Tack/fit-up of plate splice butt joint LD025-001-001 using TL508 electrode was also noted. Preheating of plate splice butt joint

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LD025-001-001 using ceramic thermal blanket prior welding was also observed.

Bay 8: Tower Diaphragm

The QA Inspector randomly observed ZPMC welder Xu Pei Pei ID Number 050323, utilizing the SAW Process in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-3221-B-U3c-S-1, to weld the CJP fill pass on 75mm thick plate splice butt joint of tower diaphragm NSD1-SA244A/B-1B. QA Inspector randomly observed ZPMC CWI Lvliqing monitoring weld parameters.

This QA randomly observed ZPMC welder Zhang Qingquan ID #045203 ID #045240 utilizing the FCAW Process with a 1.4mm diameter electrode, filler metal brand E71T-1, class Supercored 71H in the 1G (Flat Groove) Position with ZPMC WPS WPS-B-T-2231-B-U2-F to weld CJP fill pass on plate splice butt joint on FB020-006-108 and flange to web plate corner joint FB025-003-127 respectively. The QA Inspector randomly observed ZPMC CWI Hu Wei Qing monitoring preheat and weld parameters.

Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, (858) 232-7081, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
